



An ISO 9001
Company

Bharat Heavy Electricals Limited

(High Pressure Boiler Plant)

Tiruchirappalli – 620014, TAMIL NADU, INDIA

CAPITAL EQUIPMENT/ MATERIALS MANAGEMENT

ENQUIRY	Phone: +91 431 257 70 49 Fax : +91 431 252 07 19 Email : csguna@bheltry.co.in Web : www.bhel.com
NOTICE INVITING TENDER	

TWO PART BID	Enquiry Number:	Enquiry Date:	Due date for submission of quotation:
Tender to be submitted in two parts.	2620900212	29.09.2009	05.11.2009

You are requested to quote the Enquiry number date and due date in all your correspondence. This is only a request for quotation and not an order.

Please note that under any circumstances both **delayed offer** and **late offers** will not be considered. Hence vendors are requested to ensure that the offer is reaching physically our office before 14.00 hrs on the Date of tender opening.

Item	Description	Quantity
10	5 Ton Semi Gantry Crane Span 14 M as per the technical specification, general guidelines instructions & commercial conditions applicable (to be downloaded from web site www.bhel.com or http://tenders.gov.in)	6 Nos

Important points to be taken care during submission of offer

1. **Delivery required 10 months from the date of purchase order.**
2. **Grace period of 2 months beyond the above delivery period will be considered.**
3. **Checklist to be filled and enclosed along with the offer failing which, the offer will not be considered for evaluation.**
4. **Vendors are requested to submit their price bids along with technical bid individually for all the four sizes (Span x Lift x CT) indicated in Part B – Technical Specifications.**
5. **The Quantity of Tender is Firm. (i.e., 6 Nos.) However the size wise quantity may vary according to final requirement. This confirmed size wise (Span x Lift) quantity will be communicated to vendors before Price Bid opening / Conduct of Reverse Auction.**

BHEL's General guidelines / instructions (refer MM/CE/GT/001) including bank guarantee formats and list of consortium banks, commercial terms check-list can be downloaded from BHEL web site <http://www.bhel.com> or from the Government tender website <http://tenders.gov.in> (public sector units > Bharat Heavy Electricals Limited page) under Enquiry reference "2620900212".

Tenders should reach us before 14:00 hours on the due date Tenders will be opened at 14:30 hours on the due date Tenders would be opened in presence of the tenderers who have submitted their offers and who may like to be present	Yours faithfully, For BHARAT HEAVY ELECTRICALS LIMITED Sr.Manager / MM / Capital Equipment
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PART A**SECTION-I: -QUALIFING CRITERIA**

The BIDDER/VENDOR (OEM) has to compulsorily meet the following requirements to get qualified for consideration of the technical offer for the SUPPLY OF SEMI GANTRY CRANE

S. No.	PARTICULARS	VENDOR'S RESPONSE
1.0	<p>Only those Bidder/vendor (OEM), who have supplied and commissioned at least ONE 5Ton capacity Gantry or Semi Gantry crane, class-3 with minimum span of 10 Mtr or higher and should have supplied frequency converter drive for similar capacity crane in the past five years and such crane is presently working satisfactorily for more than one year after commissioning (on the date of opening of Tender), should quote.</p> <p>However, if such crane has been supplied to BHEL, then it should be presently working satisfactorily for more than six months after its commissioning and acceptance (on the date of opening of Tender) in BHEL.</p> <p>Performance certificate from the customers (minimum 2) regarding satisfactory performance of machine supplied to them in attached format should be enclosed along with technical offer.</p>	
2.0	<p>BHEL reserves the right to verify the information provided by vendor. In case the information provided by vendor is found to be false/ incorrect, the offer shall be rejected.</p>	
3.0	<p>The bidding FIRM should have 'in-house' or 'self-owned' facility for FABRICATION and TESTING at 125 % of the rated capacity</p>	
4.0	<p>The vendor should have minimum 10 years experience in design, fabrication and supply of cranes.</p>	
5.0	<p>DELIVERY - The bidder shall quote the best possible delivery. However the delivery shall not exceed 10 months with an additional grace period of 2 months. The additional grace period will attract a penalty which is explained in the commercial terms of the enquiry. The delivery period shall be reckoned from date of purchase order to despatch from the vendor works.</p>	

SECTION – II

The vendors are requested to provide the following details

S. No.	PARTICULARS	VENDOR'S RESPONSE
6.0	Number of Years of Experience of the BIDDER/ VENDOR (OEM) in the field of design, manufacture, supply, erection & commissioning of cranes	
7.0	Number of cranes supplied, installed and commissioned till date	
8.0	Number of cranes supplied, installed and commissioned till date in the QUOTED MODEL	
9.0	Number of cranes supplied, installed and commissioned till date for the following category of CUSTOMERS a) Power Utility Boiler Manufacturer b) Equipment Supplier for Process Industries [Heavy Engineering Companies] c) Research Establishments	
10.0	Details on SERVICE-AFTER-SALES Set-Up in India including the Addresses of Agents / Service Centre in India and Asia	
11.0	Any Additional Data to supplement the manufacturing capability of the BIDDER for the subject equipment.	

SECTION – III

Bidder / Vendor (OEM) to note the following

S.No.	REQUIREMENTS	VENDOR'S RESPONSE
12.0	The BIDDER / VENDOR shall submit the offer in TWO PARTS - Technical [with PART A & PART B] & Commercial and Price Bid.	
13.0	The Offer shall contain a comparative statement of Technical Specifications given by BHEL and the Offer Details submitted by the Bidder, against each clause. Where details are required, a mere 'CONFIRMED' or 'COMPLIES' or 'YES' or 'NO-DEVIATION' or similar words in the technical comparative statement may lead to disqualification of the Technical Offer.	
14.0	The Technical Offer shall be supported by Product Catalogue and Data Sheets in ORIGINAL and complete technical details of 'Bought-Out-Items' with copies of Product Catalogue and Selection Criteria	
15.0	The Commercial Offer (given with the Technical Offer) shall contain the Scope of Supply and the Un-Priced Part of the Price-Bid, for confirmation	
16.0	BIDDER has to indicate the Country of Origin for the supply of equipment.	

PERFORMANCE CERTIFICATE

(On Customer's Letter Head)

1. Supplier of the Equipment :

2. Make & Model of the Equipment :

3. Month & Year of Commissioning :

4. Application :

5.
 - a) Crane Type:

 - b) Crane Capacity (Metric Tonnes):

 - c) Crane span :

 - d) Mechanism class :

6. Performance of the Equipment : Satisfactory /
(Strike off whichever is not applicable) Good /
Average /
Not Satisfactory

7. Any other remarks:

Date:

Signature & Seal of the Authority
Issuing the Performance Certificate

PART B.

TECHNICAL SPECIFICATIONS FOR 5 T SEMI GANTRY CRANES WITH DOUBLE GIRDERS

S.No.	PARTICULARS	BHEL SPECIFICATIONS	VENDOR'S OFFER
1.0.0	APPLICATION	a. The subject crane is meant for the purpose of handling small to medium (within the lifting capacity of the crane) components, in a heavy and large steel fabrication shop floor. b. The crane will be put to use for continuous duty with CT, LT and Hoist movements, which may occur simultaneously (within the operating parameters specified under Clause Nos. – 3.1.0, 3.4.0 and 3.5.0). c. The shop floor environment will be dust prone, humid, welding fume filled and ambient temperature going up to 45 ° C , due to pre-heating of jobs.	
2.0.0	SCOPE OF SUPPLY	a. Design as per Tender Specifications b. Detailed Design, Manufacture, Assembly and Testing before Despatch c. Supply in Modules / Sub-Assemblies d. Commissioning and Performance Prove-Out at BHEL Works e. Performance Guarantee for 12 months, from the date of commissioning.	
3.0.0	TECHNICAL SPECIFICATIONS		
3.1.0	CAPACITY	Lifting Capacity	
3.1.1	Main Hoist	5 Metric Tonnes	
3.1.2	Auxiliary Hoist	NO AUX HOIST	

CABS-3-60N-5 T Semi Gantry Crane- Part-B

S.No.	PARTICULARS	BHEL SPECIFICATIONS	VENDOR'S OFFER
3.2.0	SPAN	Wheel Centre to Wheel Centre Dimensions	
3.2.1	Long Travel (LT) & Height of Lift	1. 14000mm / 5600mm 2. 14000mm / 3500mm 3. 11000mm / 5600mm 4. 11000mm / 3500mm	Rate may be quoted for each item separately.
3.2.2	Cross Travel (CT)	1,600 mm	
3.3.0	Height of Lift		
3.3.1	Height of Lift	As above	
3.3.2	Rail to Rail Height	1. 5600 mm 2. 3500 mm (Rail on the Floor to Rail on Side Bracket)	
3.4.0	DUTY CYCLE	Related to Drive Motor & Mechanisms	
3.4.1	Hoists	40 % CDF	
3.4.2	Long Travel	40 % CDF	
3.4.1	Cross Travel	40 % CDF	
3.5.0	SPEED	Operating / Working Speed [Maximum]	
3.5.1	Main Hoist	5.0 mtrs./minute.	
3.5.2	Cross Travel (CT)	15.0 mtrs./minute.	
3.5.3	Long Travel (LT)	30.0 mtrs./minute.	
3.6.0	MOTOR RATINGS	Electric Motor Ratings & Frame Sizes shall be as per IS-325 and IS-1231 and also suitable for 300 starts per hour.	
3.6.1	Main Hoist	Min 6.7 kW – Frame size - 160 M/6 Pole	
3.6.2	Cross Travel (CT)	Min 2.6 kW - Frame size - 132 M/6 Pole	
3.6.3	Long Travel (LT)	Min 2.6 kW x 2 - Frame size - 132 M/6 Pole	
3.7.0	GEAR BOX	Gear Box Size	
3.7.1	Main Hoist	HR 525 mm	
3.7.2	Cross Travel (CT)	VR 275 mm	
3.7.3	Long Travel (LT)	VR 450 mm	

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S.No.	PARTICULARS	BHEL SPECIFICATIONS	VENDOR'S OFFER
3.8.0	ACCELERATION		
3.8.1	Cross Travel (CT)	300 mm / sec.sq.	
3.8.2	Long Travel (LT)	300 mm / sec. sq.	
3.9.0	HOIST ROPE DETAILS	Size and Number of Falls of Rope	
3.9.1	Main Hoist	Dia. 12 mm ; Falls - 4	
3.10.0	CONTROL	Cabin Control only	
3.11.0	Type of Control	Master Control	
3.12.0	Control Voltage	110 V AC	
3.13.0	Input Power Supply	415 V with $\pm 10\%$ fluctuation , 50HZ with $\pm 3\%$ fluctuation, 3 Phase- AC	
3.14.0	Duty Class	Class – 3 [Indoor Service]	
3.15.0	Mechanism Group Classification	M 6	
3.16.0	DESIGN STANDARD	IS – 807 & 3177 / 2006	
3.17.0	Runway Rail Size		
3.17.1	Cross Travel (CT)	ISR 60 Lbs./Yard	
3.17.2	Long Travel (LT)	CR 80	
3.18.0	Wheel Size		
3.18.1	Cross Travel (CT)	250 mm	
3.18.2	Long Travel (LT)	400 mm	
3.19.0	Brake Drum Size	Hoist Brake Drum Sizes	
3.19.1	Main Hoist	200 mm	
3.19.2	Cross Travel (CT)	160 mm	
3.19.3	Long Travel (LT)	160 mm	
4.0.0	MAIN FEATURES	Crane Operational Features	
4.1.0	Control System	Frequency Converter type for all motions	
4.2.0	Crane Operation	From Cabin with Push Button operation	
5.0.0	STRUCTURAL FABRICATION	Crane Structure Constructional Details	
5.1.0	Bridge / Leg/ End Carriage/ Bogie	PLATE FORMED Box type Construction	

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S.No.	PARTICULARS	BHEL SPECIFICATIONS	VENDOR's OFFER
5.2.0	Raw Material	IS: 2062 Only steel plates tested and certified for quality by reputed inspection authorities, shall be used. Test Certificates to be produced for BHEL verification and form part of the documentation.	
5.3.0	Welded Joints	To be followed for Bridge/leg Fabrication	
5.3.1	Number of Joints allowed	For Span upto 23 mtrs. - Two joints For Span 23 mtrs. to 32 mtrs. - Three joints	
5.3.2	Welding Electrodes	a. For all Horizontal Welding E 7018 / ER70S-6 (MIG) Electrode only should be used. b. For all Vertical Welding E 7048 / ER70S-6 (MIG) Electrode only should be used.	
5.3.3	Welded Joint Testing	All Butt Welded Joints (both compression / tension and flanges / web joints) shall be subjected to 100% X-Ray Testing and X-Ray Films to be produced for BHEL verification and form part of the documentation.	
5.4.0	Splice Joints	NO SPLICE JOINT IS ALLOWED IN GIRDER FABRICATION [Girder has to be of SINGLE PIECE only].	
5.5.0	Platform on Girders	The Platforms provided on both the Girders shall be fixed through BOLTED JOINTS using fit bolt only.	
5.6.0	Wheel Assembly	The Wheel Assembly coming for Cross Travel (CT) & Long Travel (LT) shall be of LIVE AXLE SYSTEM with L-Type Bearings. [Refer to BHEL Drawing No. 3-M-02R-0011993 . Drawing is enclosed and given as ANNEXURE -1].	

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S.No.	PARTICULARS	BHEL SPECIFICATIONS	VENDOR's OFFER
5.7.0	Heat Treatment & NDT Examination	The Trolley shall be Stress Relieved if required after welding and NDT examinations. All weldings shall be tested by NDT means [MPI, LPI & RT].	
5.8.0	Machining Operation	All mechanical mating surfaces and wheel seating areas are to be machined to the required finish and protected	
5.9.0	Surface Cleaning	Both the Girders, legs, end-carriages and the Trolley are to be thoroughly cleaned after completion of all operations but prior to painting.	
5.10.0	Painting	The crane parts are to be painted as follows : a. One coat of Primer with 25 microns of DFT (Dry Film Thickness) and 48 hours of compulsory curing after painting. b. Two coats of Enamel Paint (Colour – Golden yellow) each with a DFT of 25 microns and intermittent curing of minimum 16 hours.	
6.0.0	MECHANICAL ELEMENTS		
6.1.0	Gears	Gears in all the Stages shall be helical in design and to be of machined, lapped/ground and hardened.	
6.2.0	Gear Box Casing	Shall be of fabricated type and stress relived by thermal heat-treatment process, prior to machining.	
6.3.0	Gear & thruster oil	Required grade oil should be supplied	
6.4.0	Rope Drum	Shall be of fabricated type and stress relieved. The circumferential weld joints shall be tested by 100 % X-Ray for quality assurance. Or seamless pipe to suit the requirement	

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S.No.	PARTICULARS	BHEL SPECIFICATIONS	VENDOR'S OFFER
6.5.0	Type of Coupling	Only GEARED COUPLING to be used a. between Electric Motor and Gear Box b. between Gear Box and Rope Drum c. between Gear Box and Trolley Wheels	
6.6.0	Wheels	The Wheels shall be of Forged and Wheel Tread hardened to 300/350 BHN. Wheels shall be fitted with L-Type Bearings	
6.7.0	Mechanical Joints	Fit Bolts as per IS 3640-1982 for all joints coming in main members and platform with reamed holes	
6.8.0	Pulley Dimension	Rope Pulley diameter shall be 23 times that of Rope diameter	
6.9.0	Hook	Hook latch shall be provided for both hooks	
6.10.0	Tools	The following tools of makes acceptable to BHEL shall be supplied along with each crane (Vendor to clearly specify the makes of each items in the offer)	
6.10.1	List of Tools	1 Double end spanner -one set 2 Ring spanner -one set 3 Hammer 2lbs -one no 4 Screw driver -one set 5 Screw spanner -one set 6 Cutting pliers -one set 7 line tester -one no 8 Grease gun -one no	
7.0.0	ELECTRICAL ELEMENTS		
7.1.0	Operational Controls	The Crane shall be provided with the Cabin Control [Master Control] - Push Button Type]	
7.2.0	Control Voltage	110 V AC	
7.3.0	Type of Brakes	a. Main Hoist - DCEM Brake b. Cross Travel - Thruster Brake c. Long Travel - Thruster Brake	

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S.No.	PARTICULARS	BHEL SPECIFICATIONS	VENDOR's OFFER
7.4.0	Protection	All Panels, Limit-Switches and Motors shall have IP 54 protection. (Outdoor Service)	
7.5.0	Electric Contactors	All Panels shall have only SIEMENS / L&T Contactors and shall be suitable for AC3 Duty Class.	
7.6.0	Contactors Rating	The rating of all Contactors shall be atleast 50% higher than the respective electric motor full load current, at the specified duty cycle.	
7.7.0	Long Travel Motion	A Dual Drive Mechanism shall be provided for LT (Long Travel) Motion.	
7.8.0	Controller Steps	4-Step 40amps master Controller with two neutral inter lock has to be provided for a. Main Hoist b. Long Travel c. Cross Travel	
7.9.0	Crab Wiring	The CRAB shall be fully wired without junction box.	
8.0.0	SELECTION of BOI and COMPONENTS	The makes of Components or Bought-Out-Items shall be strictly as per the list given below.	
8.1.0	Hoist Hooks	HERMAN MOHTTA / HERCULES / SILPA UDYOG / SMRITI FORGINGS / KARACHIWALA	
8.2.0	Wire Rope	USHA MARTIN / FORT WILLIAM / RA WIRE ROPE	
8.3.0	Electric Motors	GEC / BHARAT BIJLEE / SIEMENS / KEC/ ALSTHOM	
8.4.0	Thruster Brake Unit	ELECTROMAG / SPEED-O-CONTROL / OMEGA	
8.5.0	Limit Switch (Gravity Type)	SIEMENS / INDUSTRIAL SYNDICATE / BCH / SKC / SOC	
8.6.0	Contactors	SIEMENS / L&T	
8.7.0	Over-Load-Relay	SIEMENS / L&T (THERMAL TYPE)	
8.8.0	HRC Fuses	GE / L&T /SIEMENS	

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S.No.	PARTICULARS	BHEL SPECIFICATIONS	VENDOR's OFFER
8.9.0	Rotary limit switch	SIEMENS / OMEGA / SOC / INDUSTRIAL SYNDICATE	
8.10.0	Switch fuse unit	L&T / SIEMENS / GEC	
8.11.0	Moulded case CB	SIEMENS / L&T	
8.12.0	Pneumatic Time Delay	Only BCH make	
8.13.0	Push - Buttons	SIEMENS / L&T / AIRON	
8.14.0	Connectors	ELMAX make or reputed make with IS approved with acceptable BHEL	
8.15.0	Couplings	WMI / FENNER / ALFEX/REPUTED	
8.16.0	Bearings	SKF / NBC / ZKL	
8.17.0	Cables	Reputed Makes & ISI Approved acceptable by BHEL.	
8.18.0	Resistance box	OHMARK / BCH	
8.19.0	VVVF Drives	ABB / SIEMENS / L&T	
8.20.0	DCEM brakes	BCH only	
9.0.0	DOCUMENTS/ DETAILS for APPROVAL	The following documents and details are to be submitted for BHEL Approval, prior to taking up the manufacture of the crane.	
9.1.0	Drawings and Documents	<p><u>Set I:</u></p> <ul style="list-style-type: none"> a. Calculations for Selection of Electric Motors, Gear Reducers, Brakes, Couplings, etc. b. Calculations for Bridge Girder, Legs, Crab, End - Carriage and their connections. c. GA Drawing of the Crane. d. GA Drawing of Trolley e. GA Drawing of Individual Mechanisms. 	

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S.No.	PARTICULARS	BHEL SPECIFICATIONS	VENDOR'S OFFER
9.1.0	Drawings and Documents	<p><u>Set II:</u></p> <ul style="list-style-type: none"> a. Drawings of Bridge, Legs, End-Carriage bogies and their connection. b. Sub-Assembly Drawing for Wheels, Hook Blocks, Gear Boxes, Hoist rope drums and all brake Drums. c. Wiring Diagram with Logic Circuits. d. Cable Selection based on Current Rating. <p>Initially Set I drawings to be submitted in one lot and approval to be obtained from BHEL. Based on this, set II drawings to be submitted for approval.</p>	
9.2.0	Technical Details	<ul style="list-style-type: none"> a. Total Weight of the Crane including all Electrical Equipment b. Total Weight of Trolley including all Electrical Equipment c. Weight of each Bridge assembled and ready for erection with and without Mechanical and Electrical Equipment. d. Weight of End-carriage assembled and ready for erection e. Total Weight of Structural, Mechanical and electrical Equipment and indicated separately also. f. Weight of Operator's Cabin together with all Equipment mounted in it. 	
10.0.0	INSPECTION	The following Schedule of Stage Inspections is to be strictly adhered to, prior to dispatch from the Supplier's Works	

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S.No.	PARTICULARS	BHEL SPECIFICATIONS	VENDOR'S OFFER
10.1.0	STAGE – I	a. Verification of Test Certificate for Raw Materials used for Girders, legs, End-Carriages, Trolley, Gear Box Casings, etc. b. Verification of X-Ray Report of Butt-Joints coming in the Girders and Random Testing on the Welds, by physical examination. c. Box Girder setting before closing of the Bottom Flanges – for inspecting the quality of welding and presence of waviness d. Trolley Frame Fabrication before setting the Mechanisms e. End-Carriage Fabrication before closing of the Bottom Flanges	
10.2.0	STAGE – II [Final Inspection]	a. Inspection of Bridges, legs, End-Carriages and platform fabrication. b. Verification of Span & Diagonal Dimensions, Checking of Wheel Alignment, Mechanical Assemblies and Total Alignment. c. Free running of all the Mechanisms. d. Measurement of CAMBER in the Bridges. e. Full / Rated Load Test for bridges and trolley and Deflection Test f. Deflection and Permanent Set Measurement. g. 25% OVER-LOAD Lifting Ability Check.	
11.0.0	CRANE ERECTION & COMMISSIONING		
11.1.0	Mechanical Erection	Erection of the Crane will be done by BHEL, as per the guidelines furnished in the Erection Manual given by the supplier.	

CABS-3-60N-5 T Semi Gantry Crane- Part-B

S.No.	PARTICULARS	BHEL SPECIFICATIONS	VENDOR's OFFER
11.2.0	Crane Commissioning	Commissioning of the Crane and Performance Prove –Out for 125% of Crane’s Capacity and Smooth Functioning of the Crane (at BHEL Works) shall be the RESPONSIBILITY of the supplier.	
12.0.0	O & M MANUALS	Each Crane shall be provided with THREE Copies of Erection, Operation & Maintenance Manual hard copy as well as soft copy in CD, containing the following technical details	
12.1.0	Drawings & Details	<ul style="list-style-type: none"> a. Crane GA Drawing b. Crab Assembly Drawing c. Total Crane Wiring Schematics d. Detailed Wiring Diagrams for Sub-Systems / Panels e. Wheel Assembly Drawings f. Bottom Block Assembly Drawing g. Gear Box Assembly Drawings h. Coupling Drawing and Details i. Specifications/Ratings of All Bought-Out-Items j. Warranty / Guarantee Card for all Bought-Out-Items k. Trouble Shooting Chart for Main and all Sub-Systems 	
13.0.0	PERFORMANCE GUARANTEE	The Performance of the Total Crane and/or the Components / Sub-Assemblies / Bought-Out-Items shall be guaranteed for a minimum period of twelve months from the date of performance acceptance at BHEL Works or 18 months from the date of supply whichever is earlier.	